

Date: Tuesday, 14/10/2008 1:21:45 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PLUG - BLUE
Job Number :	42564		
Estimate Number :	10512		
P.O. Number :		Part Number :	D26511
This Issue :	14/10/2008	Drawing Number :	D2651 REV. B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	14/10/2008	Drawing Revision :	
Previous Run :	41636	Material :	
Written By :		Due Date :	31/10/2008
Checked & Approved By :			Qty: (88) Um: Each
Comment :	Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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(88)

Comment: Qty.: 0.0421 f(s)/Unit Total: 3.7052 f(s)
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500)
 Batch: 1109396

mmf 08/10/17

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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(88)

Comment: HAAS CNC VERTICAL MACHINING #1
 1- Turn as per Folio FA219 and Dwg D2651
 2- Deburr

mmf 08/10/17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(88)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/10/17

4.0	QC8	SECOND CHECK
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(88)

Comment: SECOND CHECK

H.A 08/10/17

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr ias per dwg D2651

mmf 08/10/20

88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 1:21:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG - BLUE

Job Number: 42564

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



88

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FJ

08/10/21

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINT DELFLEET BLUE

CLEAR DELFLEET

Batch 105918 + 109333

(Only larger section necessary)

MF 08 11 06

88

8.0

QC14

INSPECT SPRAY PAINT



08-11-07

88

Comment: INSPECT SPRAY PAINTING

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-A

MF

08-11-07

88

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

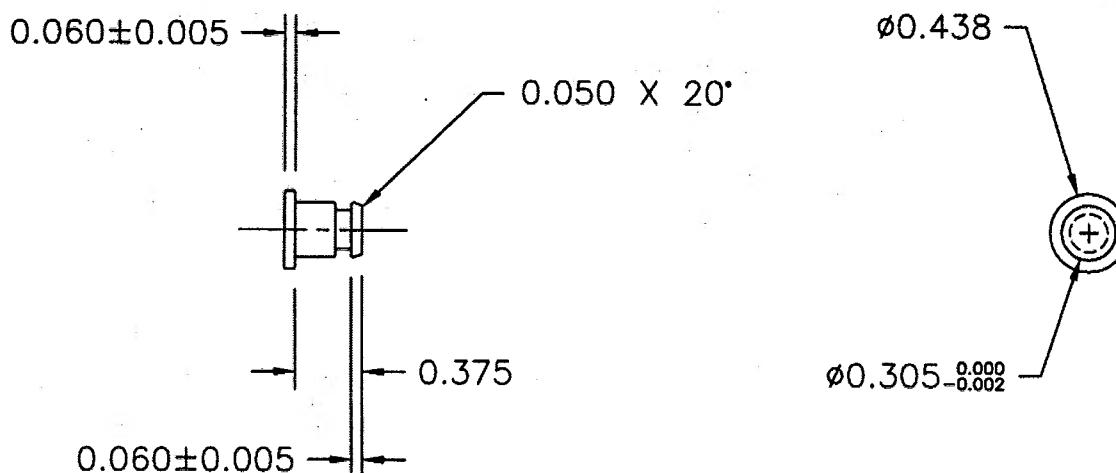


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

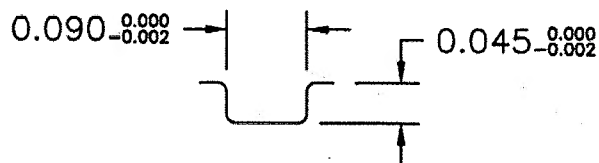
RELEASED

03.12.19 [Signature]

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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NO. 42564

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